

Tuesday, June 06, 2017 4:57:33 PM

162440

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/8/2017 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 6/15/2017 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: DAS Date: JUN 08 2017

Tooling: _____ Date: _____

Run Start *NR1*

QC: 9-89 Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.3900	C2 ✓

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

120	0.00
-----	------

120

Small Fab	Memo	0.64
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Small Fab

Memo

Assemble as per dwg and apply loctite 598 on all faying surfaces per note.

A/R RTV LOCTITE 598: 137797
exp. date: 04/19

130	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

130

QC	Memo	0.04
----	------	------

Quality Control

DAS

38

9.29

JUL 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 162440

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162440

Page 2

Item ID: 647.3902 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Deflector Assembly, High
Start Date: 6/8/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CCF071</u>	0.00							
140									
Packaging	Memo	0.02							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.20							
Quality Control									

17/7/24 *[Signature]*

DAS
21 JUL 20 2017
9-39

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>								Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																								
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																								
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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																			
Description Work Order Deviation				Disposition				Completed By																			
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Root Cause				FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																			
OTHER : ☐																											

Picklist Print

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Work Order ID: 162440

162440

Parent Item: 647.3902

647.3902

Parent Item Name: Lower Deflector Assembly, High

Start Date: 6/8/2017

Required Date: 6/15/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.09.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.3912		Manufactured	No			110	Each	9.0000	1	2	DAS 6 9-89	JUL 18 2017	
647.3912									**				

Breakaway Tip Wirestrike for Wire Strike Kit

Location	Loc Qty	Loc Code
CCK077	9	
158496	6	
158883	3	

647.3914		Manufactured	No			110	Each	8.0000	1	2	DAS 6 9-89	JUL 18 2017	
647.3914									**				

Breakaway Tip, Long

Location	Loc Qty	Loc Code
CCK002	8	
155355	2	
158495	6	

MS20470AD6-12		Purchased	No			110	Each	365.0000	3	6	DAS 6 9-89	JUL 18 2017	
MS20470AD6-12									**				

Rivet

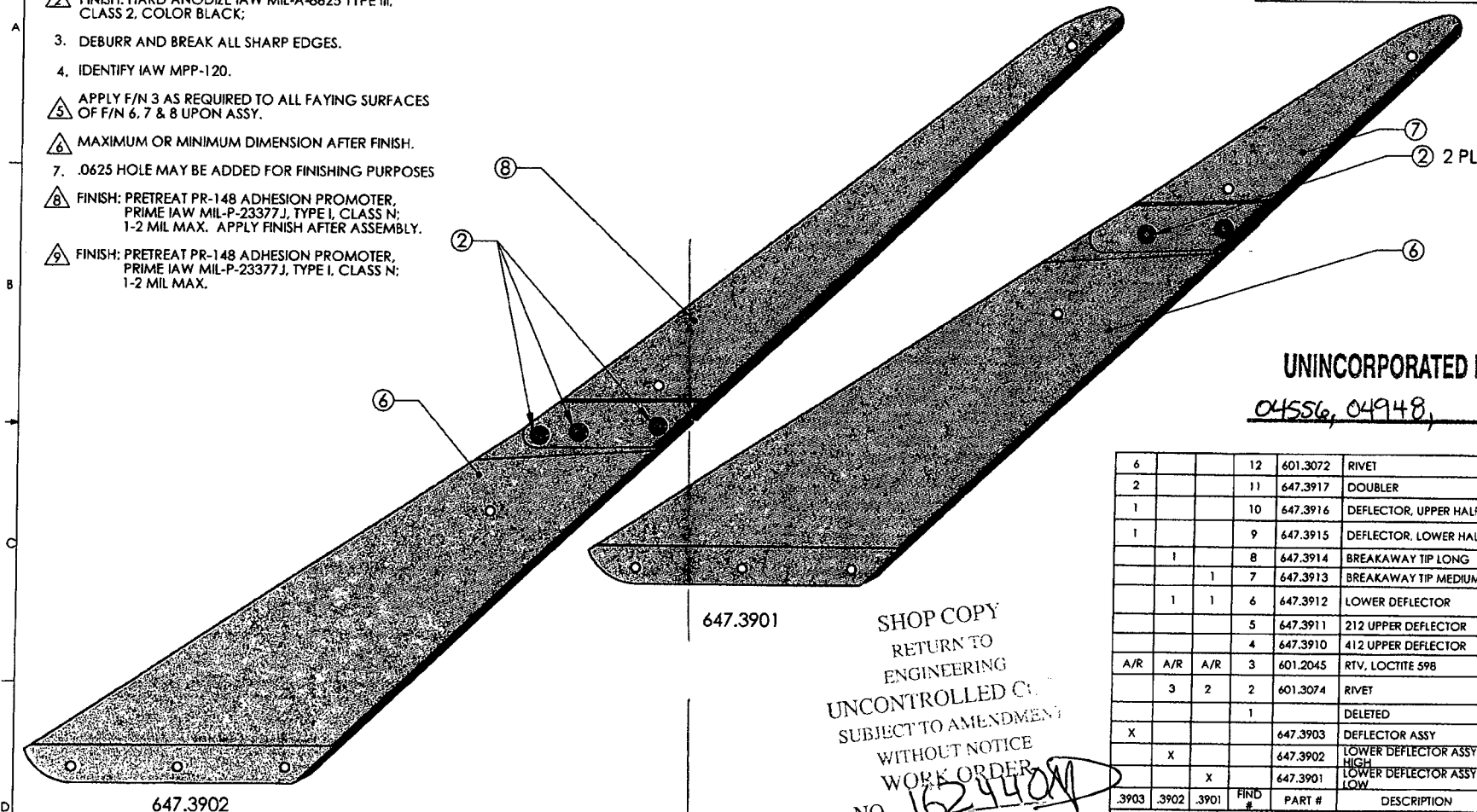
Location	Loc Qty	Loc Code
ST308	365	
m127304	4	
m136643	361	

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
6. MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES.
8. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
9. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
REV.	LAST PROTOTYPE RELEASE: P1		YIC
NIC	INITIAL RELEASE	07/10/07	P. BRAVO
A	INCORPORATED ECN 0584, 0357 & 0359	07/24/13	P. BRAVO
B	INCORPORATED ECN 04023	08/02/13	P. BRAVO
C	INCORPORATED ECN 04038, 04085 & 04290	11/18/13	P. BRAVO



UNINCORPORATED ECN(s)

04556, 04948,

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162440M

JUL 18 2017

6			12	601.3072	RIVET	CR3213-6-9	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△△
			5	647.3911	212 UPPER DEFLECTOR	△	△△
			4	647.3910	412 UPPER DEFLECTOR	△	△△
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	2	601.3074	RIVET	MS00470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
	X			647.3902	LOWER DEFLECTOR ASSY HIGH		
		X		647.3901	LOWER DEFLECTOR ASSY LOW		
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.3800				DRAWN BY: DUCHUR			
				DRAWING APPROVAL: P. BRAVO			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				3 PLACE DECIMALS ±.01			
				ANGLES ±.5°			
				APICAL INDUSTRIES			
				2608 TEMPLE HEIGHTS DR.			
				OCEANSIDE, CA. 92056-3512 (760)724-5300			
				DEFLECTORS			
				SEE CAGE CODE DWD. NO. 647.3900			
				REV. C			
				SCALE NONE			
				SHEET 1 OF 12			